

6695



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G08451-3G
Job Sheet 180505



JLS #30

B-2h

Part No: RBW6205G08451-3G

Job Qty: ~~9 ea~~

Part Name: Puller Bolt Removal

10



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 7/7/18

Job Tracking No:

Due Date: ~~8/10/18~~ 8/15

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G08451-3G Rev. 2B IPP Rev. A 18.06.12 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	9 Ea		8/10/18	0.00	0.00	Start Up Machining-2		JB 18-09-13
110	CNC Lathe	9 pcs		8/10/18	0.00	2.25	MORI SL-154		JB 18-09-13
120	QC	9 pcs		8/10/18	0.00	0.00	QC2 Machining-4		JB 18-09-13
130	QC	9 pcs		8/10/18	0.00	0.00	QC8 Machining-4		JA 18-09-14
150	Outsource	9 pcs		8/10/18	0.00	0.00	Outsource4		CE 18-9-17
160	Packaging	9 pcs		8/10/18	0.00	0.00	Packaging2		SEP 7 2018
170	QC	9 pcs		8/10/18	0.00	0.00	QC6		38
180	Packaging	9 pcs		8/10/18	0.00	0.00	Packaging3-1		7/10/18
190	QC21-FG	9 Ea		8/10/18	0.00	0.00	QC21		18-09-13

Part Op 110 - 1-Machine as per DWG. FC 315 FOLIO REV: _____ DWG REV: _____ 2-Deburr 29
 Descriptions: 130 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.
 150 - Issue P/O to GROUPE ALTECH PO: 01025 - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2
 CLASS 1 WATER SEAL -Material; 6061 - Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.375	6061-T6 Round Bar 1.375"	5.4000 ft (.6 ea)	90-Start up Operation	5069913

M6061 T6 R1.375

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.375	5	21	0



Container No: S109798



Part: RBW6205G08451-3G

Job No: 180505

Serial No/Batch: S109798

Revision: 2B

Inspector:

Exp Date:

Instructions:

Date: 09/13/18

ations

not be found.

Plex 8/23/18 2:12 PM dart.logan.david

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE**DART**
AEROSPACE

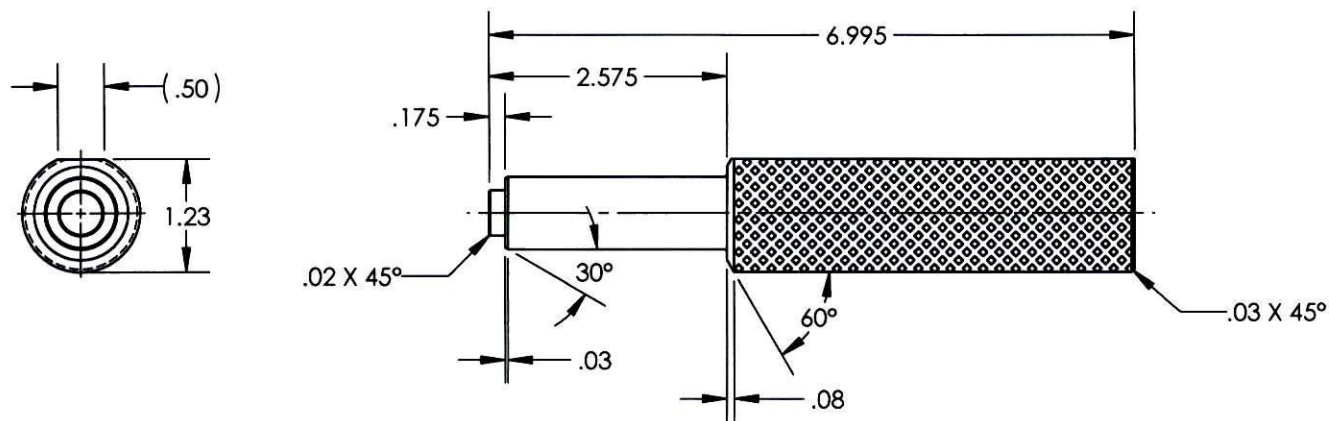
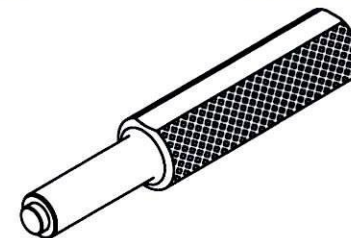
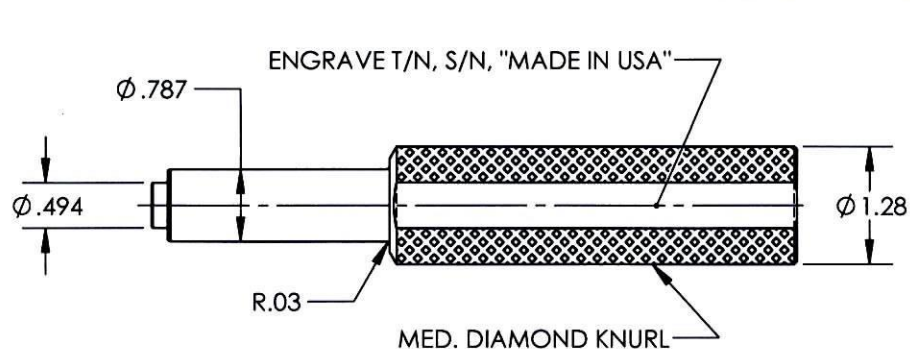
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																						
Large Fab ☐	Composite ☐	Supplier ☐																																																																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																																		
Description Work Order Deviation				Disposition			Completed By																																																																		
							Lead hand / Supervisor Approval Verification																																																																		
							QC / QA Coordinator Approval																																																																		
Root Cause <table style="width:100%; border: none;"> <tr> <td style="border: none;">Environment ☐</td> <td style="border: none;">No Re-verification ☐</td> <td style="border: none;">Pressure/Forced ☐</td> </tr> <tr> <td style="border: none;">Design ☐</td> <td style="border: none;">Operator ☐</td> <td style="border: none;">Bending ☐</td> </tr> <tr> <td style="border: none;">Doc/Data ☐</td> <td style="border: none;">Offset/Setup ☐</td> <td style="border: none;">Centre Not Concentric ☐</td> </tr> <tr> <td style="border: none;">Equip/Tooling ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;">Cracks ☐</td> </tr> <tr> <td style="border: none;">Handling/Pre ☐</td> <td style="border: none;">Training ☐</td> <td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td> </tr> <tr> <td style="border: none;">Material ☐</td> <td style="border: none;">Use for Testing ☐</td> <td style="border: none;">Cuffs ☐</td> </tr> <tr> <td style="border: none;">Internal Transport ☐</td> <td style="border: none;">Poor Information ☐</td> <td style="border: none;">Crushing ☐</td> </tr> <tr> <td style="border: none;">Tribal Knowledge ☐</td> <td style="border: none;">Rushing ☐</td> <td style="border: none;">Heat Treat ☐</td> </tr> <tr> <td style="border: none;">LOA ☐</td> <td style="border: none;">Product Improvement ☐</td> <td style="border: none;">Wave/Twist in Tube ☐</td> </tr> <tr> <td style="border: none;">Substation ☐</td> <td style="border: none;">Process Improvement ☐</td> <td style="border: none;">Marks/Chatter ☐</td> </tr> <tr> <td style="border: none;">Past Expiry Date ☐</td> <td style="border: none;">Manufacturing Process ☐</td> <td></td> </tr> <tr> <td style="border: none;">Misidentified ☐</td> <td style="border: none;">Past Due ☐</td> <td></td> </tr> </table>				Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Design ☐	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐		FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="border: none;">Temperature/Cure ☐</td> <td style="border: none;">Power Loss/Surge ☐</td> <td style="border: none;">Positioned Wrong ☐</td> </tr> <tr> <td style="border: none;">Set-up ☐</td> <td style="border: none;">Folio/Program ☐</td> <td style="border: none;">Outside Dimensions ☐</td> </tr> <tr> <td style="border: none;">BOM/Route ☐</td> <td style="border: none;">Grain ☐</td> <td style="border: none;">Over/Under tolerance ☐</td> </tr> <tr> <td style="border: none;">Broken/Damage/Defect ☐</td> <td style="border: none;">Weld ☐</td> <td style="border: none;">Part Incorrect ☐</td> </tr> <tr> <td style="border: none;">Inspection Incomplete/Unqualified ☐</td> <td style="border: none;">Wrong Stock Pulled ☐</td> <td style="border: none;">Part Lost/Missing ☐</td> </tr> <tr> <td style="border: none;">Contamination ☐</td> <td style="border: none;">Out of Sequence ☐</td> <td style="border: none;">Part Moved ☐</td> </tr> <tr> <td style="border: none;">Countersink ☐</td> <td style="border: none;">Off-set ☐</td> <td style="border: none;">Drawing ☐</td> </tr> <tr> <td style="border: none;">Cut Too Short ☐</td> <td style="border: none;">Mislabeled ☐</td> <td style="border: none;">Finish ☐</td> </tr> <tr> <td style="border: none;">Instructions Incomplete/Unclear ☐</td> <td style="border: none;">Fit/Function ☐</td> <td style="border: none;">Misread ☐</td> </tr> <tr> <td style="border: none;">Drill Holes ☐</td> <td style="border: none;">Misaligned/off center ☐</td> <td style="border: none;">Turning Sequence ☐</td> </tr> </table>				Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Countersink ☐	Off-set ☐	Drawing ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Environment ☐	No Re-verification ☐	Pressure/Forced ☐																																																																							
Design ☐	Operator ☐	Bending ☐																																																																							
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐																																																																							
Equip/Tooling ☐	Supplier ☐	Cracks ☐																																																																							
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐																																																																							
Material ☐	Use for Testing ☐	Cuffs ☐																																																																							
Internal Transport ☐	Poor Information ☐	Crushing ☐																																																																							
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐																																																																							
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐																																																																							
Substation ☐	Process Improvement ☐	Marks/Chatter ☐																																																																							
Past Expiry Date ☐	Manufacturing Process ☐																																																																								
Misidentified ☐	Past Due ☐																																																																								
Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																							
Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																							
BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																							
Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																							
Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																							
Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																							
Countersink ☐	Off-set ☐	Drawing ☐																																																																							
Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																							
Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																							
Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																							
OTHER : ☐																																																																									

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	ADDED .455 REF. DIMENSION.	9/24/2009	WP	GE
1	CH'D HANDLE DIA., FROM $\phi 1.20$ TO $\phi 1.28$. REF. DIM. WAS .455 IS NOW .767.	9/28/2009	WP	GE
2	CH'D OD. WAS $\phi 1.28$ IS $\phi 1.276$. MILLED FLAT WAS .51 IS .587 REF. AND .767 REF. TO .50 REF. CH'D .032x60° TO .03 @ 30°, AND .08x60° TO .08@60°. ALSO ADDED VISIBLE KNURLING.	10/3/2009	WP	RW
2A	CH'D WAS CLEAR HARD ANODIZING IS CLEAR ANODIZING AND ADDED KNURL NOTE.	10/27/2010	WP	GE
2B	SEPERATED TOOLS FROM KIT RBW6205G00331-3G. CH'D DIM. LOCATION WAS REF. .587 IS 1.23. ADDED AW139 TO USED ON MODEL.	10/17/2013	CFS	RW



RED BARN MACHINE	
TITLE M/R BLADE RETENSION BOLT PULLER	
DWG NO. RBW6205G08451-3G	REV 2B
MAT'L 6061	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH CLEAR ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS I
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA AW139
SCALE 1:2	DATE 10/17/2013
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	PULLER	6061	$\phi 1-3/8$ X 7-1/8	1



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041025**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041025
PO Date: 9/17/18
Due Date: 9/21/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180505	RBW6205G08451-3G	Puller Bolt Removal -Issue P/O to GROUPE ALTECH PO: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Material; 6061 - Certificate of Conformity is required	Firmed	-	9/21/18	10 pcs	0 pcs	10 pcs	\$4.95/pcs	\$49.50
10 X SEP 24 2018 DAS 38 9-89											
Line Item Note ** RUSH **											
2	178257	RBEM633V3002102-23	Thimble -Issue P/O to GROUPE ALTECH PO: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL - Certificate of Conformity is required	Firmed	-	9/21/18	6 pcs	0 pcs	6 pcs	\$3.916666/pcs	\$23.50
6 X SEP 24 2018 CT.											



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041025**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	178261	RBEM633V3002102-7	Lateral Clamp Plate -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	9/21/18	12 pcs	0 pcs	12 pcs	\$3.916666/pcs	\$47.00
Grand Total:											\$120.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/18/18 2:19 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(012750-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

012750 - 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
21-Sep-2018		Aman		PO041025 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6205G08451-3G ✓ Rev.	RBW6205G08451-3G 01-ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	10 ✓	10	0	0	0
2	RBEM633V3002102-23 ✓ Rev.	RBEM633V3002102-23 01-ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	6 ✓	6	0	0	0
3	RBEM633V3002102-7 ✓ Rev.	RBEM633V3002102-7 01-ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	12 ✓	12	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.